



Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D2873-045
Job Sheet 185084



Part No: D2873-045

Job Qty: 20 ea

Part Name: Nut Plate Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/22/18

Job Tracking No:

Due Date: 11/9/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A IPP A 05.09.13 New issue KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea	11/9/18	11/9/18	0.00	0.00	Start Up Machining-1		mm L 18/11/18
100	Bandsaw	20 pcs	11/9/18	11/9/18	0.00	0.18	Bandsaw1		11
110	CNC Vertical Machining	20 pcs	11/9/18	11/9/18	0.09	5.08	HAAS1-2		11
120	QC	20 pcs	11/9/18	11/9/18	0.00	0.00	QC2 Machining-1		11
130	QC	20 pcs	11/9/18	11/9/18	0.00	0.00	QC8 Machining-1		mm L 18/11/18
140	Small Fab	20 pcs	11/9/18	11/9/18	0.00	0.56	Small Fab-2		mm L 18/11/18
150	QC	20 pcs	11/9/18	11/9/18	0.00	0.00	QC5		38
160	HandFinish	20 pcs	11/9/18	11/9/18	0.00	0.41	HandFinish1		D.R 18/11/18
170	QC	20 pcs	11/9/18	11/9/18	0.00	0.00	QC7-1		SMB
180	Small Fab	20 pcs	11/9/18	11/9/18	0.00	0.56	Small Fab-2		SMB
190	QC	20 pcs	11/9/18	11/9/18	0.00	0.00	QC5		38
200	Packaging	20 pcs	11/9/18	11/9/18	0.00	0.00	Packaging3-1	LG050	AR 18-11-17
210	QC21-SA	20 Ea	11/9/18	11/9/18	0.00	0.00	QC21		DAS 21

Part Op 100 - Cut blanks: 1.000" x 0.375" x 2.700" long

Descriptions: 110 - Machine as per Folio FA and Dwg D2873 Identify as D2873-5 Dwg Rev ____ F1819Folio Rev ____

140 - 1-Debur

180 - 1-Assemble as per Dwg D2873 2-Identify as D2873-045

200 - LOCATION : LG050

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.500X01.000	6061-T6 Bar .500 X 1.00	4.5000 ft (.225 ea)	90-Start up Operation	
MS20426AD4-6	Rivet	80 Ea (4 ea)	180-Small Fab	
MS21075L5	Nut Plate	40 Ea (2 ea)	180-Small Fab	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B0.500X01.000	5	6	0
180-Small Fab	MS20426AD4-6	80	1,909	0
	MS21075L5	40	304	0

Part Specifications

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																		
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																		
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																		
Large Fab ☐	Composite ☐	Supplier ☐																			

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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Description Work Order Deviation	Disposition	
		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval

Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	FAULT CATEGORY Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

Specifications could not be found.

Plex 10/22/18 1:31 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

DART AEROSPACE LTD		Work Order:	185084
Description: Radius Block		Part Number:	D2873-5
Inspection Dwg: D2873 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.50	+/-0.030	2.502	-		vern	mark 05
1.000	+/-0.010	1.001	-			
0.750	+/-0.010	0.750	-			
0.250	+/-0.010	0.254	-			
1.000	+/-0.010	1.000	-			
2.000	+/-0.010	2.00	-			
Ø0.128	+0.005/-0.001	0.131	-			
0.359	+/-0.010	0.359	-			
Ø0.316	+0.006/-0.001	0.318	-			
1.000	+/-0.010	1.000	-			
0.250	+/-0.010	0.250	-			
0.061	+/-0.010	0.061	-			
Ø0.230 x 0.125	+0.005/-0.001 x 0.010	0.228 x 0.128	-			

Measured by:	measured	Audited by:	aud	Prototype Approval:	N/A
Date:	18/11/08	Date:	18/11/11	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.08.30	New Issue P/O D2873-045	KJ/JLM	



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CANADA
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www.dartaerospace.com

Container No: S125817



Part: D2873-045

Job No: 185084

Serial No/Batch: S125817

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/08/18

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